

Date: Thursday, 5/31/2007 7:21:03 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP RH (FOLDING)
 Job Number : 32714
 Estimate Number : 12568
 P.O. Number : *N/A*
 This Issue : 5/31/2007 S.O. No. : *NA*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 29385
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est. Rev: A New Issue 06-11-08 JLM

Part Number : D412630034
 Drawing Number : IIN D412-630 REV K
 Project Number : N/A
 Drawing Revision : K
 Material : *N/A*
 Due Date : 6/11/2007 Qty: *3* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG002

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty Part Number Description
 1 D2012-107 Clevis

Batch

1329883

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number Description
 1 D2803-042 Bracket Assembly RH

Batch

1329392

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number Description
 1 D2804-042 Bracket Assembly RH

Batch

*1326952**7/10/490*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/11	18	split u/o		SB	07/06/11			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:21:04 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

1328487

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

1325923

7.0

D3562042

STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch

1325923 B 32720

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

1327291, 1325935, 1326770

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

119633, 7/6/4 SQ

W/O:		WORK ORDER CHANGES						
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Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

⑤
M100695

①
M102736

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M100433

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M103286, 76/4 SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M102067

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M103691

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

7/6/450

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M101472

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M17045

MF 07-06-18

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-06-18 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

M29393 ✓✓

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

M29394 ✓✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

M27287 ✓✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

M27290 ✓✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M102039 ✓✓

7/6/450

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M100273 ✓

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M101291 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M101711 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M100229 ✓

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M101428 ✓ 7/6/4 54

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 27/06/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H5

Description

Washer

Batch

(3X)

(18)

M100925

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

4 MS21043-4

Description

Nut

Batch

M104537

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

3 MS21043-5

Description

Nut

Batch

M101418

7/6/45P

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

EP 7/6/22 (2) CD 7/10/22 (2)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev: A

EP 7/6/25 (2) C

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EP 07/05/25

Job Completion



n 07/05/25

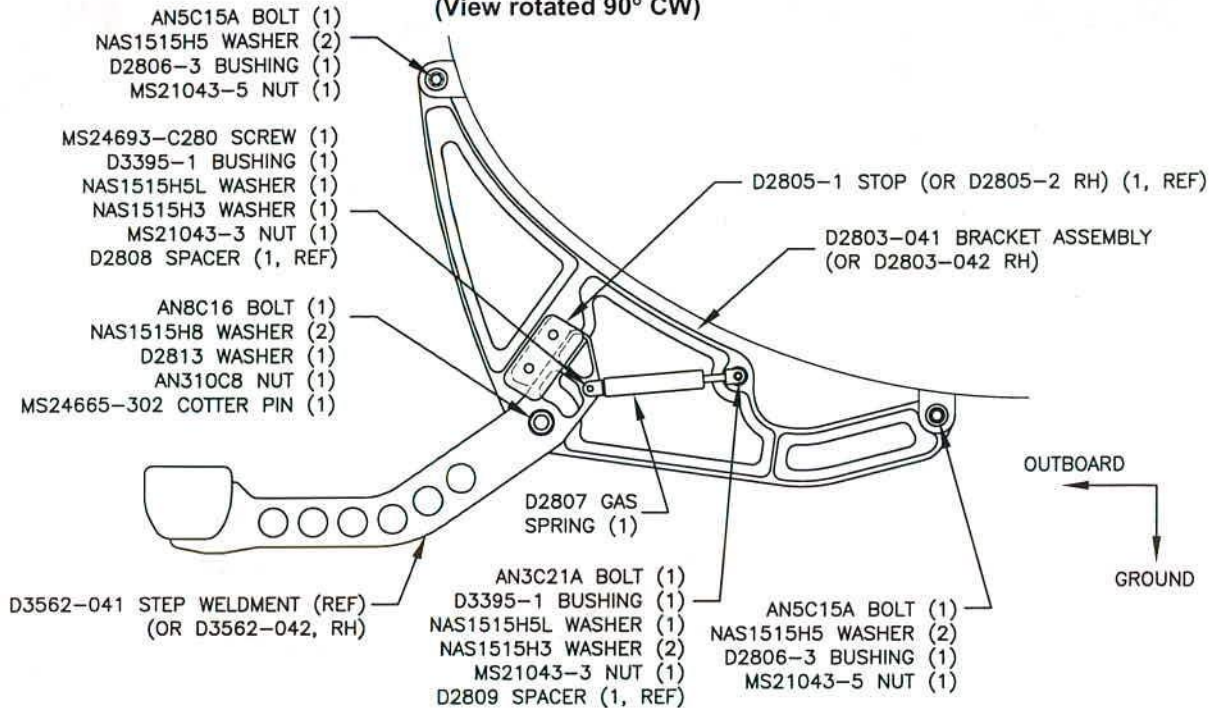
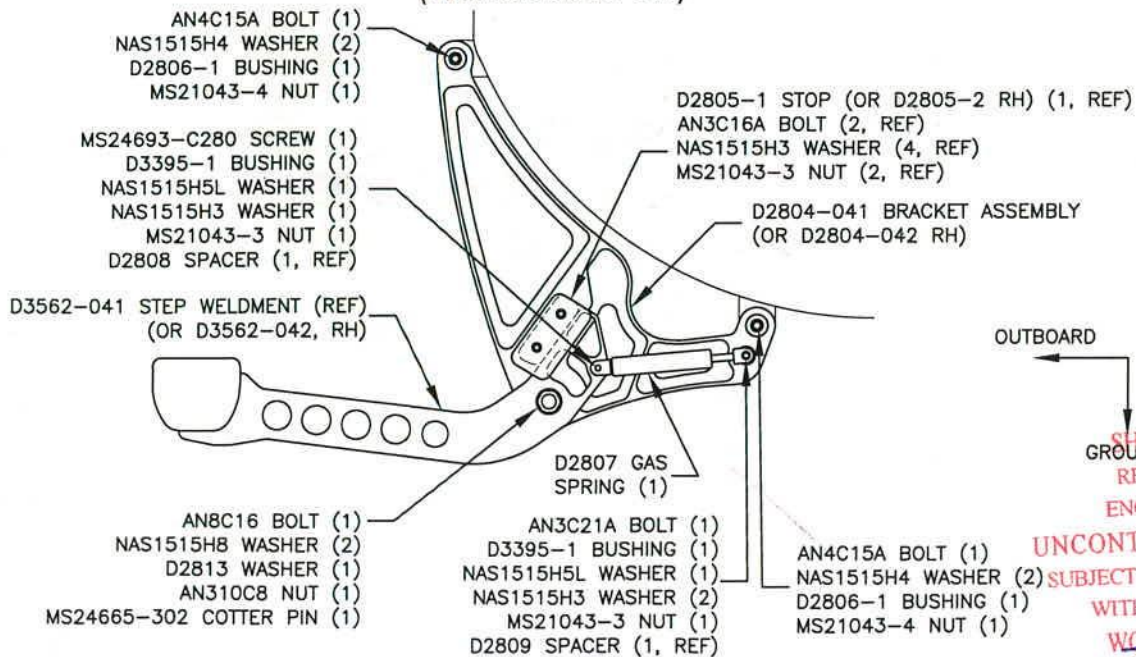
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32714

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Revision: **K**
Date: 06.10.05